

Date: Thursday, 11/15/2007 1:27:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY
Job Number : 35779
Estimate Number : 10911
P.O. Number :
This Issue : 11/15/2007 S.O. No. :
Prsht Rev. : NC Part Number : D3405041
First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : D3405 REV A
Previous Run : 32890 Drawing Revision : A
Written By : Due Date : 12/2/2007 Qty: 20 Um: Each
Checked & Approved By :
Comment : Est A 05.09.01 New issue KJJ/LM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total: 3.2340 sf(s)
304/316 .125 Sheet
(M304S11GA)
Batch: 104934 B 07-11-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3405
Dwg Rev. A B 07-11-19
Prog Rev.:

2-Deburr if necessary B 07-11-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Deburr
Form using DT8204 as per Dwg D3405

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 35779

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

✓ 08/01/22 (X29)

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

A/R

SS Rod

B35810 → 10x B34849 → 10x
M10615 8/1/22 ✓

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

8/1/22 (20x)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-23 (20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-24 (20)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 106379 8/1/28 (20)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/1/28 SD (20x)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 474

8/1/28 SD (20x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
98.10.31	7	static balance of D3405-1 x 9	[Signature]	98.10.30	9	[Signature]	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 08/10/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:27:09 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 35779

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(29)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/31

Job Completion



u 08/01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

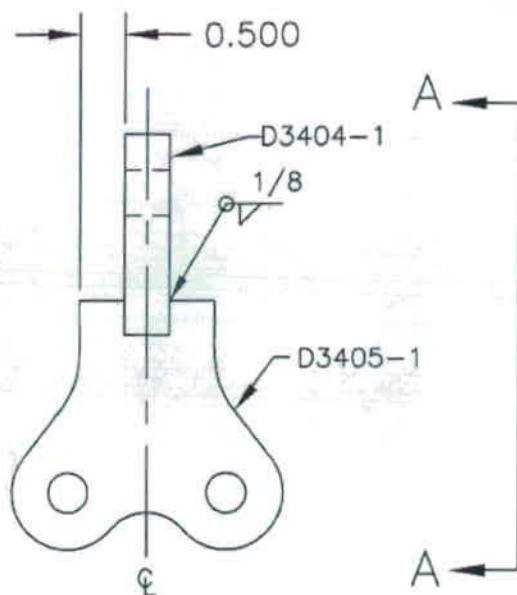
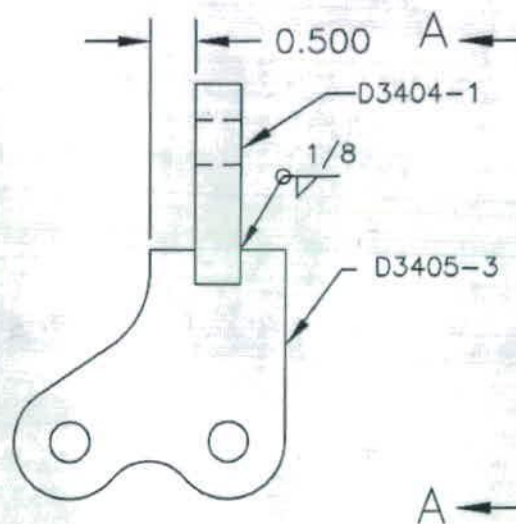
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

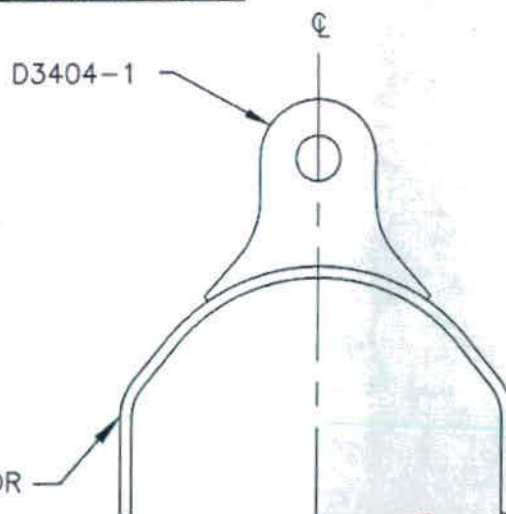
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09 *[Signature]*D3405-1 OR
D3405-3**D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

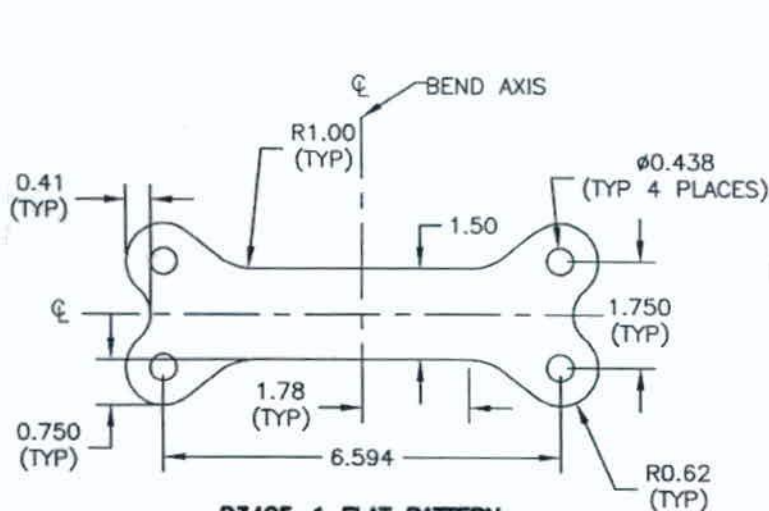
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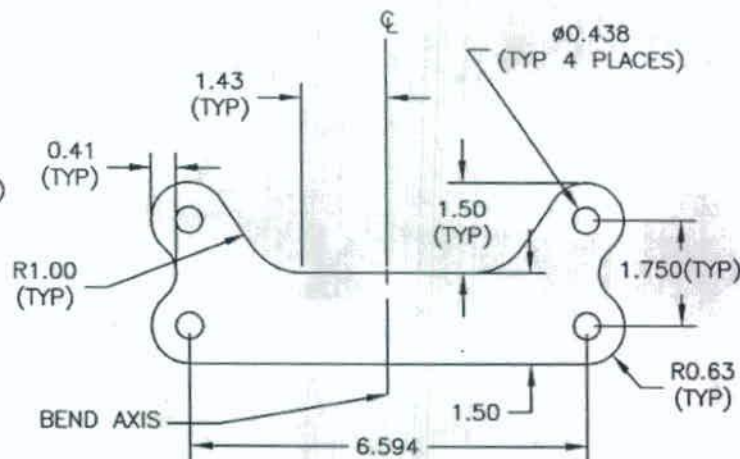
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DART

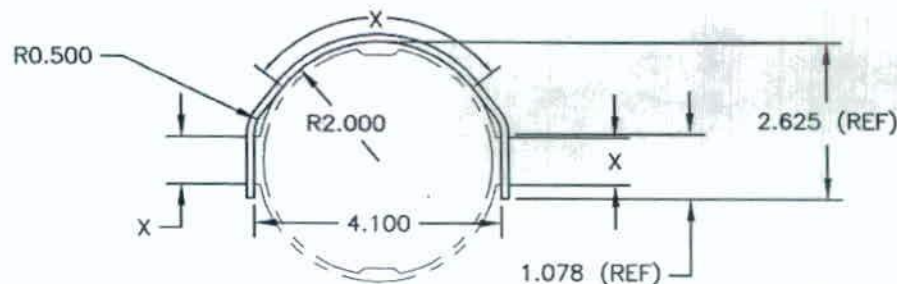
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 05.08.09
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